

Wire type:
TIG Solid wire

Current:



Welding positions:



Shielding gas:

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Fer SGNi1 is our solid wire for TIG welding low alloyed structural steel having a nominal yield strength up to 550 MPa used in applications where good sub-zero toughness is required down to -60°C. Typical applications include heavy machinery, petrochemical equipment and offshore constructions. To be used in combination with tungsten electrodes type WS2 Witstar®.

Base materials to be welded:

- Ships plate A-E, A(H)32-E(H)36, S315G1S-S355G3S
- Structural steel S185-S355K2G4, St.33-St.52.3, C(K)10-C(K)35
- Boiler steel P235GH-P355GH
- Fine grain steel SP355NL2-S500QL1, S275N-S420ML
- Pipe steel P235T1-P355N, L360-L485MB/NB, St37.0-St52.4, St45.8, X52-X70
- Cast steel GP240R, GS45

Applications:

- Shipbuilding & Offshore
- General fabrication & construction
- Power Generation
- Repair & Maintenance

Chemical composition, wt.% weld metal – typical:

C	Mn	Si	Ni
0,09	1,05	0,50	0,90

Mechanical properties, weld metal – typical:

Condition	0,2% Yield strength MPa	Tensile strength MPa	Elongation Lo=5d - %	Impact Values ISO-V J
As welded	≥ 470	≥ 550	≥ 20	20°C ≥ 100 -60°C ≥ 47

Packaging data:

Dia. mm.	Length mm.	Weight / package kg.
1,6	1000	5
2,0	1000	5
2,4	1000	5